

CLAIMS

What is claimed is:

- 1 1. A method for manufacturing a piston comprising a disk-shaped
2 base body having opposed sides, through-channels between the sides, and a support
3 raised above one of the sides for supporting a valve disk, each said through-channel
4 being surrounded by a support body raised above one side for supporting a valve disk,
5 and a recess recessed below the opposite side, said method comprising:
6 receiving said base body between a pair of die tool halves, and
7 pressing a forming tool into one of the body to form said support by
8 material flow.
- 1 2. A method as in claim 1 further comprising removing material within
2 said support to provide a through-opening.
- 1 3. A method as in claim 2 wherein the diameter of the forming tool is
2 smaller than the diameter of the through-opening.\
- 1 4. A method as in claim 1 comprising pressing a pair of forming tools
2 into respective opposed sides of said base body synchronously to form a pair of said
3 opposed supports on respective opposed sides of said base body by material flow.
- 1 5. A method as in claim 1 wherein said tool die halves comprise said
2 forming tool, said method comprising:

3 providing a stamping blank for said base body, said stamping blank having
4 a greater thickness than said base body after pressing said forming die therein; and
5 forming said support by upsetting said tool die halves so that the forming
6 tool is pressed into said one of said sides.

1 6. A method as in claim 5 wherein the differential volume between the
2 stamping blank and the base body after pressing said forming die therein flows into said
3 support.